

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 53813

November 18, 2009 1:46:40 PM



Page 2

Item ID: D3155-3

Accept



Setup Start



Revision ID: D

Stop



Item Name: Bushing

Start Date: 18/11/2009 Start Qty: 20.00



Cust Item ID:

Required Date: 25/11/2009 Req'd Qty: 20.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

130

Identify as per dwg & Stock Location: 42

0.00



Packaging

Memo

0.00

Packaging

10/01/06 (20)

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/01/06 MF
10-01-06

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NOTE: Date & initial all entries

Picklist Print

November 18, 2009 1:46:46 PM

Page 1

Work Order ID: 53813

Parent Item: D3155-3RevD

Parent Item Name: Bushing

Start Date: 18/11/2009

Required Date: 25/11/2009

Comments:

Start Qty: 20.00

Required Qty: 20.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
SS-812-20		Purchased	No				Each	13.0000	4.0000			

Bushing

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

13

101102

13

7.0

SS 10/01/05

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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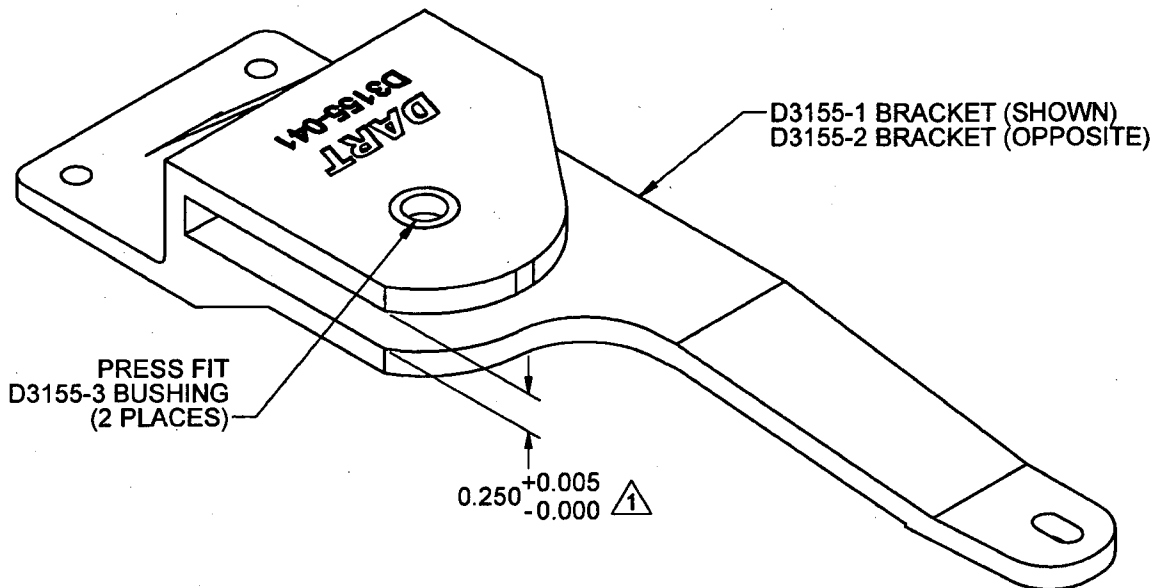
NOTE: Date & initial all entries



DESIGN #	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED #	DRAWING NO. D3155	REV. D SHEET 1 OF 3
DATE 07.01.18		TITLE BRACKET ASSEMBLY SCALE 1:1	
REV	DATE	DESCRIPTION	
A	02.04.24	NEW ISSUE	
B	03.02.28	AS MANUFACTURED	
C	04.10.06	5.455 WAS 5.550	
D	07.01.18	ON D3155-1/-2, 0.699 DIM WAS REMOVED; 0.887 WAS 0.882; 3.150 WAS 3.148; ADD 0.250 DIM +0.005/-0.000	

RELEASED

07.01.18 **#**



D3155-041 BRACKET ASSEMBLY
(SHOWN, REPLACE PREMIER P/N B30-23000-11)
D3155-042 BRACKET ASSEMBLY
(OPPOSITE, REPLACES PREMIER P/N B30-23000-12)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AN ENDMENT
WITHOUT NOTICE
WORK ORDER
NO. **53813**
BH09-11-18

QTY -041	QTY -042	P/N	DESCRIPTION
X		D3155-041	BRACKET ASSEMBLY
	X	D3155-042	BRACKET ASSEMBLY
1		D3155-1	BRACKET
	1	D3155-2	BRACKET
2	2	D3155-3	BUSHING

NOTE:

1 MAINTAIN THE 0.250^{+0.005}_{-0.000} DIMENSION AFTER PRESS FITTING THE BUSHING.

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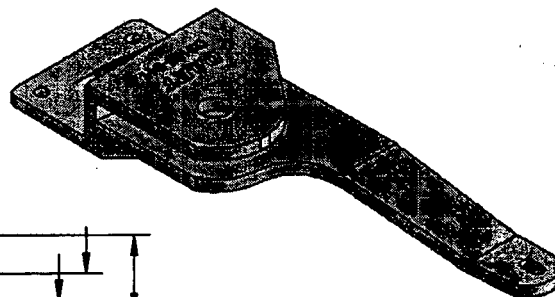
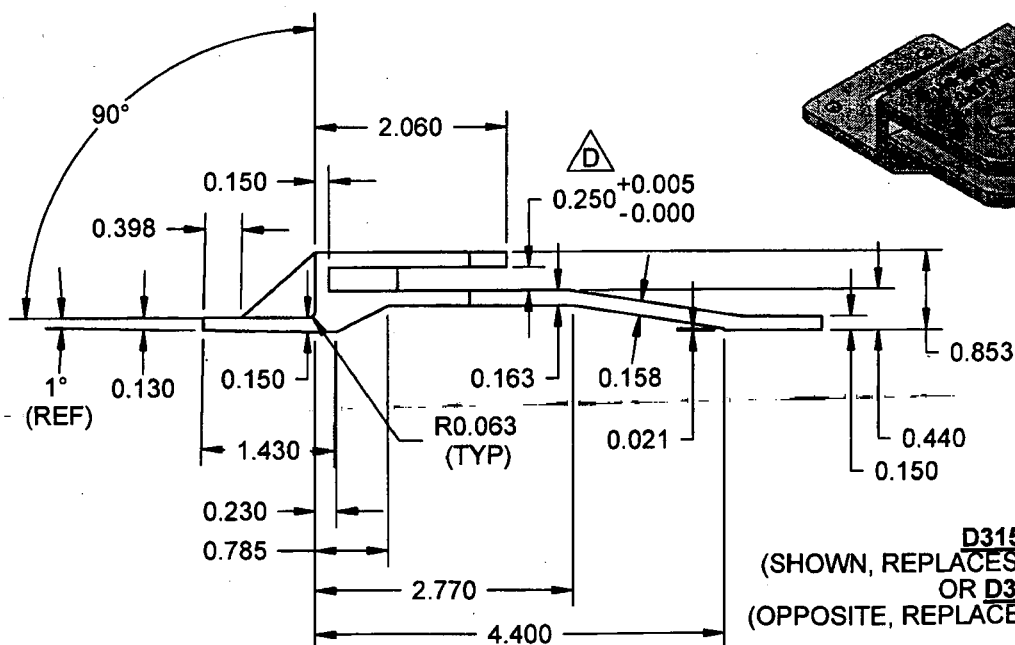
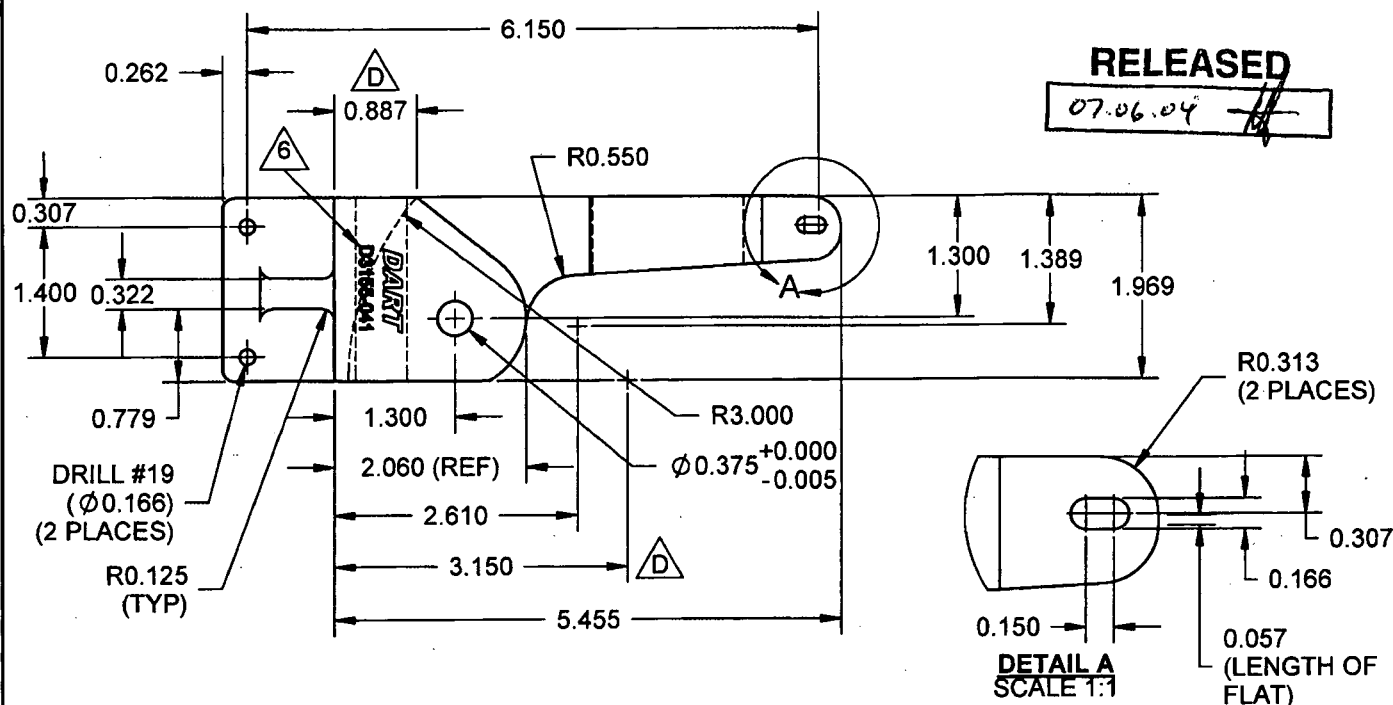
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DESIGN <i>HA</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>HA</i>	DRAWING NO. D3155	REV. D SHEET 2 OF 3
DATE 07.01.18	TITLE BRACKET ASSEMBLY		SCALE 1:2

RELEASED

07.06.04 *HA*



D3155-1 BRACKET
(SHOWN, REPLACES PREMIER P/N B30-23000-153)
OR D3155-2 BRACKET
(OPPOSITE, REPLACES PREMIER P/N B30-23000-154)

NOTES:

- 1) MATERIAL: ALUMINUM BAR 6061-T6/T651 PER QQ-A-225/8 OR QQ-A-200/8 OR AMS 4117 OR AMS 4128 OR AMS 4115 OR AMS 4116 OR AMS 4160 (REF DART SPEC M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 6) ENGRAVE DART P/N & LOGO AS SHOWN TO MAX DEPTH OF 0.010 WITH A MIN RAD OF 0.010

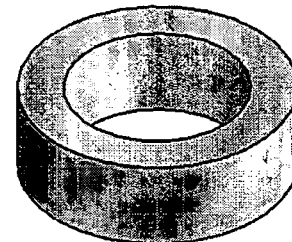
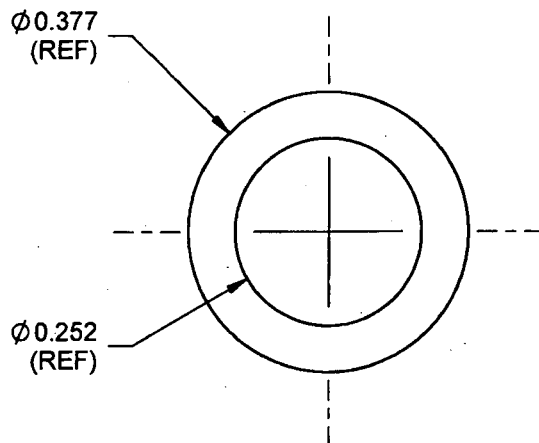
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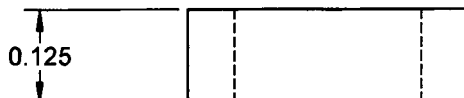
w/0 53813

DESIGN #	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED [Signature]	DRAWING NO. D3155	REV. D SHEET 3 OF 3
DATE 07.01.18		TITLE BRACKET ASSEMBLY	SCALE 4:1



RELEASED

07.06.04 [Signature]



D3155-3 BUSHING

NOTES:

- 1) MATERIAL: MAKE FROM SBS-3-3 (SOLID BAR) OR SS-812-20 (TUBING)
POSSIBLE SUPPLIER: SYMMCO
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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